

Monday, 7/9/2007 11:47:23 AM
User: Kim Johnston

Process Sheet

split into 08/03/13

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 33369
Estimate Number : 10543
P.O. Number :
This Issue : 7/9/2007 S.O. No. :
Prsht Rev. : NC
First Issue : 11 Type : MACHINED PARTS
Previous Run : 24630

Drawing Name : STUD

Part Number : D30281
Drawing Number : D3028 REV A
Project Number : N/A
Drawing Revision : A
Material :
Due Date : 7/30/2007

Qty: 38 Um: Each

Written By : *Am. 07.09*
Checked & Approved By :
Comment : Est.B 02.09.10 Made on Cobra KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 M4130NR0750

4130 steel rod .750"



Comment: Qty.: 0.1313 f(s)/Unit Total : 3.9375 f(s)
4130 steel rod .750"

Material: AISI 4130N Bar per MIL-S-6758 or AMS 6348/ 6370/ 6528 Ø0.750"(M4130N-R0.750)
atch M104452
Threads per MIL-S-7742

B

H.A 08/01/11

2.0 HARDINGE

HARDINGE CNC LATHE SMALL

Comment: ~~BAND SAW~~ *Hardinge*

1-Turn blank per Dwg D3028 and FA263
2-Cut groove as per Dwg D3028 and FA263
3-Deburr and Tumble for a short time to prevent damage to threads

H.A 08/01/11

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L / H.A 08/01/11

4.0 QC8

SECOND CHECK



Comment: SECOND CHECK

14/02.02/12 (30)

5.0 OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting PURCHASING

Issue P/O: 5683

Finish : Cadmium plate per QQ-P-416F Class 1, Type II

Material release note is required.

C208/02/12 (25)

P/O: 7434 C208/02/23 (24)

870

16/03/13 (25)

Process Sheet

CU-DAR001 Dart Helicopters Services

Drawing Name: STUD

ber: 33369

Part Number: D30281

er:



q. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

Identify and Stock

Location: _____

5760

1-8/3/3

1-8/11/4

(4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/05

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



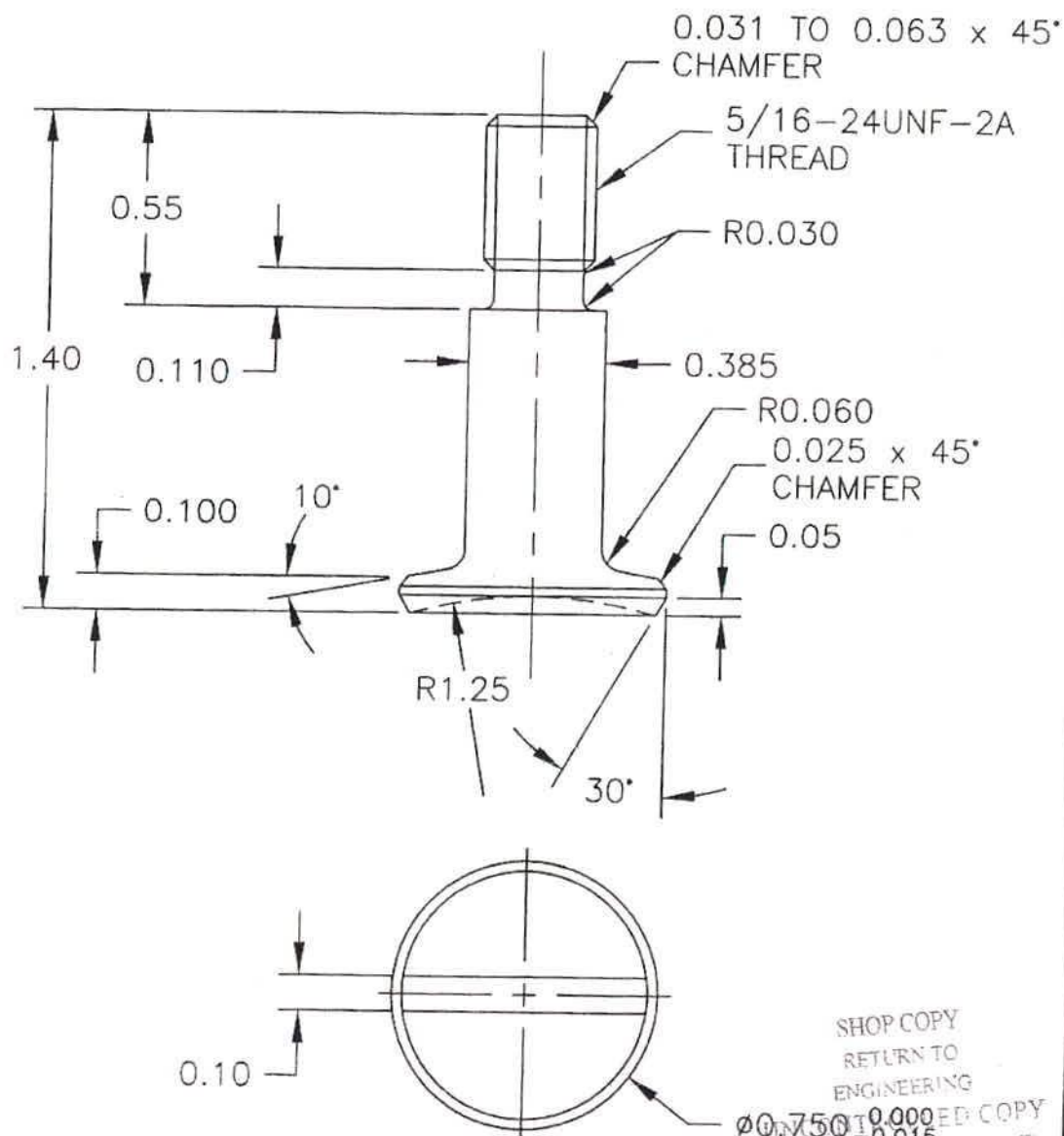
mf 08-11-05

→ 6.1 QC 6 ~~08/03/13~~ (+25)
08/11/06

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3028	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE STUD	SCALE 2:1
A	01.05.18	NEW ISSUE	

SPECIFICATION CONTROL DRAWING



D3028-1:

- 1) POSSIBLE SUPPLIER: NORTHERN AERO INDUSTRIES P/N B83602-1
- 2) MATERIAL: AISI 4130N BAR PER MIL-S-6758 OR AMS 6348/6370/6528
- 3) THREADS PER MIL-S-7742
- 4) FINISH: CADMIUM PLATE PER QQ-P-416F CLASS 1, TYPE II
- 5) ALL DIMENSIONS ARE IN INCHES.
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33369
RELEASED
01.05.30


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FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype[illegible]

Measured by:	M. A. / E. / J.
Date:	08/01/11

Audited by:	
Date:	08/02/09

Prototype Approval:	
Date:	

Date:	08/01/11	Date:	08/22/01		
Rev	Date	Change	Revised by	Approved	
A		New Issue	KJ/RF		

MANCO DOMPLEX

6895 Crescent 3
Anjou (Québec) H1J 1B6
Tél.: (514) 355-7867
Fax: (514) 355-8750

CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE

1167

Client / Customer Part Aerospace

Votre # de commande / Your purchase order # 607434

de la pièce / part # 1 lot of pieces

Notre # de bon de livraison / Our packing slip # 109155

Inspecteur / Inspector <u>Renault</u>	Date, équipe / Date, shift <u>30/10/09</u>
Placage / Plating <u>QQP-416F T-1 Re # class 1</u> <u>Sosulot</u>	
Quantité totale / Total quantity <u>1 lot</u>	Quantité inspectée / Inspected quantity <u>1 lot</u>
Adhésion / Adhesion <u>Good</u>	
Épaisseur / Thickness L.C.D. H.C.D. Moy. / aver. <u>0.0005</u>	
Coulisses, taches / Leach, spots <u>NO</u>	Rugosité / Roughness <u>NO</u>
Quantité approuvée / Approved quantity <u>1 lot</u>	Quantité rejetée / Rejected quantity

Commentaires / Comments

B 33369 = 4 pcs
B 42446 = 20 pcs

Nous certifions que les pièces énumérées ci-dessus ont été faites en conformité avec vos dessins et spécifications et rencontrent les exigences contenues dans ces dessins et/ou spécifications.

We hereby certify that the parts listed above have been made in accordance with your drawings and specifications and are correct to the requirements contained in those drawings and/or specifications.

Signé au nom de
Signed on behalf of

**MANCO
DOMPLEX**